

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026383**Date Inspected:** 10-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay 14

**WELDING**

This QA Inspector randomly observed the following work in progress:

**Shielded Metal Arc Welding (SMAW)**

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019B-002 located on floor beam to side plate of the OBG Segment 14E. The welder is identified as 051356. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019N-106/107 located on side plate stiffener of the OBG Segment 14E. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019Q-1-133 located on side plate stiffener of the OBG Segment 14E. The welder is identified as 054013. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as KP3001-001-009 and 010 located on K-Plate the OBG Segment 13AE. The welder is identified as 037748. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

### Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SA3013-001-012 located on vertical plate of the OBG Segment 13BE. The welder is identified as 045661. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007AH-095 located on Floor Beam I-Rib to SA of the OBG Segment 13AE. The welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007N-034 located on floor beam to K-plate the OBG Segment 13AE. The welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019R-049 and 05007N-034 located on side plate to bottom plate of the OBG Segment 14E. The welder is identified as 066763. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019AG-037 located on floor beam to edge beam of the OBG Segment 14E. The welder is identified as 052696. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019K-015 located on floor beam flange to longitudinal diaphragm at PP127.3 of the OBG Segment 14E. The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB. For more details please see attached photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

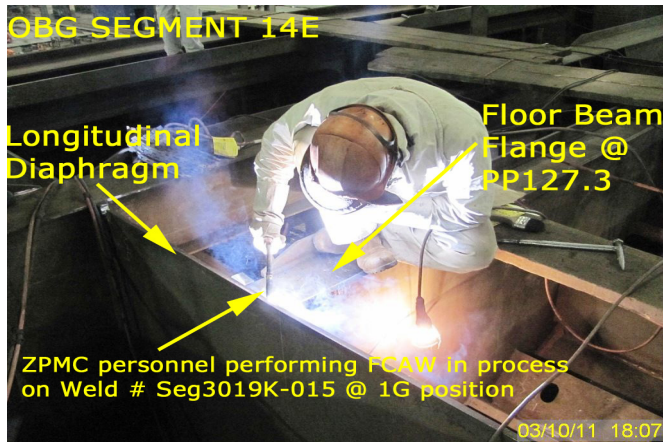
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contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Singh, Vikram	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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